Work Order Thursday, October	· ID 74970 · 13, 2011 1:57:26 PM		*749	70*						Page 1
Revision ID:	03269-2 ubble Window, RH	A	Accept	*N900	040	100)* s	etup Stai	171	S1* S2*
Start Date: 1 Required Date: 1 Reference:	0/13/2011 Start Qty: 2.00 0/21/2011 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:					
	Process Plan: MC	Date: 1\-(0-\3)	Tooling: SPC (Y/N):		te:		R	tun Star Sto	1/1	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3269	Rev E									
1 \\n Thermoform Thermoforming Mach	HAND FINISHING TH Memo ine Set up Cla	ERMOFORMING mping Frame and Load Progra	0.00 0.00 umas per Folio FTA 014				٧2			L/10/17
*110 * 1 1 \\ Thermoform Thermoforming Mach	HAND FINISHING TH Memo ine Cut Blanks	IERMOFORMING s to 30" by 48"	0.00				×2			Dl 11/10/17
120 *120* Thermoform Thermoforming Mach	THERMOFORMING I Memo Thermofor	MACHINE m as per Dwg. D3269 and FoFolio Rev	0.00 0.00 blio FTA 014 Dwg. Rev.				42			W/10/17

W/O:			W	ORK ORDER	CHANGES	3				
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			··········				· · · · · · · · · · · · · · · · · · ·		Frod Mgr	•
			· - 5.							
Part No:		PAR #:	Fault Cate	egory:		NCR: Yes	No DQ	A:	Date: _	
		esolution:								
NCR:		1	WORK ORE	DER NON-CO	NFORMAN	CE (NCF	R)	1,		
DATE	STEP	Description of NC		Corrective Act			Verific	cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng		escription f Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
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	Vork Order ID 74970 Pursday, October 13, 2011 1:57:26 PM			*74970*								Page 2
Item ID: Revision ID:	D3269-2			Accept	*N900	040	100)* s	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	Bubble Windo 10/13/2011 10/21/2011	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:				этор	^N:	S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ite:		F	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II)	Operation Description QC2- Inspect parts off m	achine FAI/FAIB	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
130 QC Quality Control		Memo 1) Check Su		0.00 I marks, voids, dimples etc	. 2) Check			7 ² .				u liol i
140 *140* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00	10(17			<u> </u>	>			

150

150 Thermoform HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Thermoforming Machine

1) Trim off excess flange material2) Buff out any light scratches or blemishes3) Etch part number and batch number

12

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W/O:			V	VORK ORDER CHA	ANGES		-			
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Prod Nigi	
						:				
Part No	•	PAR #:	_ Fault Ca	tegory:	NCI	R: Yes I	lo DQ	A:	Date:	My d System de la company
	R	esolution:	_ Disposit	ion:	QA	N/C Clo	sed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
DAIL	0.2.	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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Work Orde Thursday, Octob				*749	970*							Page 3
Item ID: Revision ID: Item Name:	D3269-2 Bubble Windo	ow, RH		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	10/13/2011	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:						
Approvals:		nn:	Date:			te:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC5- Inspect part comp	lateness to step on W/O	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
160 QC Quality Control		Memo	inspect for clarity, and p	0.00 Sul	10/17				<u> </u>			
170 Packaging Packaging		Identify as per dwg & Si Packaging Mem o	tock Location: PPF 7496	0.00						<u> </u>] (1//v)	/12(2)
¹80 *18∩*	•	QC21- Final Inspection	- Work Order Release	0.00							v. 1	10/18/
QC		Memo		0.00								

Quality Control

11-10-18

W/O:			WC	ORK ORDER CH	IANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:				R: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	n:	QA	: N/C Ci	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONF	ORMANCI	E (NCR)			
DATE	STEP	Description of NC	Section B	Γ' ••	Verifi	cation	Approval	Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Descri	ption 	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Page 1

Work Order ID:

74970

Parent Item:

D3269-2

Parent Item Name:

Bubble Window, RH

Start Date: 10/13/2011

Required Date: 10/21/2011

Start Oty: 2.00

Required Qty: 2.00

Comments:

IPP A 05.03.22 New issue

IPP B 05.05.09 A

w issue KJ/JLM Added engraving EC

IPP Rev:06-07-03

As per Rev C JLM

IPP C 07.11.06 Thermoform in-house DL verified by:EC

IPP Rev: D 08.07.24 As per New Tool DL.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRYLICS.177 0.177" PLEXIGLAS G CL	EAR CAST ACRYLI	Purchased IC SHEET	No				sf	68.7460	4	24.122105	5		- Dh
				Location therm		<u>Loc Qty</u> 68.746	Lo	c Code					11/10/
				116	796	68.746			_3	4.132105	sq. ft	<u>′</u> .	. •

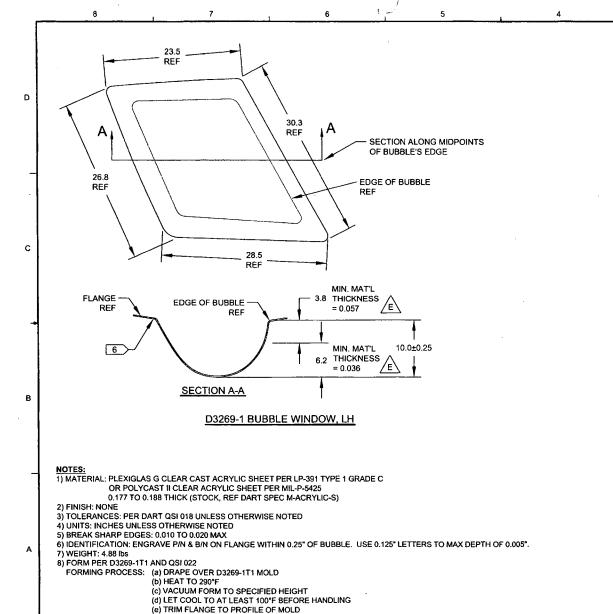
W/O:			V	VORK ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Ca	itegory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	_ Disposit	tion:	_ QA: N/C (Closed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign	9 1	cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC Inspector
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DART AEROSP	ACE LTD			Wo	rk Order:	74	970
Description: Bubb	le Window RH (R44	1)		Pa	rt Number:		03269-2
		<u> </u>					
Inspection Dwg: [3269 Rev : E					Pa	ige 1 of 1
	FIRST A	RTICLE INSP	ECTION	CHECK	LIST		
	x	First Article		Prototyp	oe .		
	. T I	HERMOFORM	MING SE	CTION			
Description			Accept	Reject	Method of Inspection		omments
Depth of bubble wit	hin tolerances						
Shape Definition			_				
Material imperfection scratching	ons such as bumps,	cracks, voids,					
							;
Measured by:		4 -			Date	: 11	110/10
measured by.	Whies	<i></i>	050516				1.6/1/
		TRIMMING	SECTION	/N	<u> </u>		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		comments
10.0	+/-0.25	10.125"					
6.2	0.036 Min	6.055"				-	
3.8	0.057 Min	0.076	V			-	
			· · · · · · · · · · · · · · · · · · ·				
							
							· · · ·
	<u></u>						1 /
Measured I	by: Dag	t 1.			Date		110/17
Audited I	by: A				Date	: 4/	0/12
Audited							
Prototype Approv					Date	:	

08.11.27 New Issue
09.10.16 Tolerances revised per Dwg Rev E

		— · · ·							•
W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:						Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC inspector
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0.057 WAS 0.095 (ZN C6-1, C7-2); 0.036 WAS 0.050 09.08.21 (ZN B6-1, B7-2) PER PAR 09-029 REFORMAT, CHG OVERALL REF DIMS, CHG FORMING PROC (A8-1,A8-2), MIN WALL WAS 0.100 NOW 0.095 08.02.13 (C6-1,C7-2) С NO LONGER TRIMMED 06.06.22 В UPDATE MATERIAL SPEC. CP 05.03.10 A NEW ISSUE CP 05.02.18 REV. DESCRIPTION BY DATE

DESIGN	4	DART AEROSE	PACE LTD
DRAWN	RF	HAWKESBURY, ONTA	RIO, CANADA
CHECKED	I.P.	DRAWING NO.	REV. E
MFG. APPR.	196	D3269	SHEET 1 OF 2
APPROVED	Meld	TITLE	SCALE
DE APPR.	d	BUBBLE WINDOW	NTS
DATE 09.	08.21	COPYRIGHT © 2005 BY DART THIS DOCUMENT IS FROM TE AND CONFIDENTIAL AND IS SUPPORT TO SE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION FROM CARE. WINDLESS PERMISSION FROM CARE.	LIED ON THE EXPRESS CONDITION THAT IT IS NICATED TO ANY OTHER PERSON WITHOUT

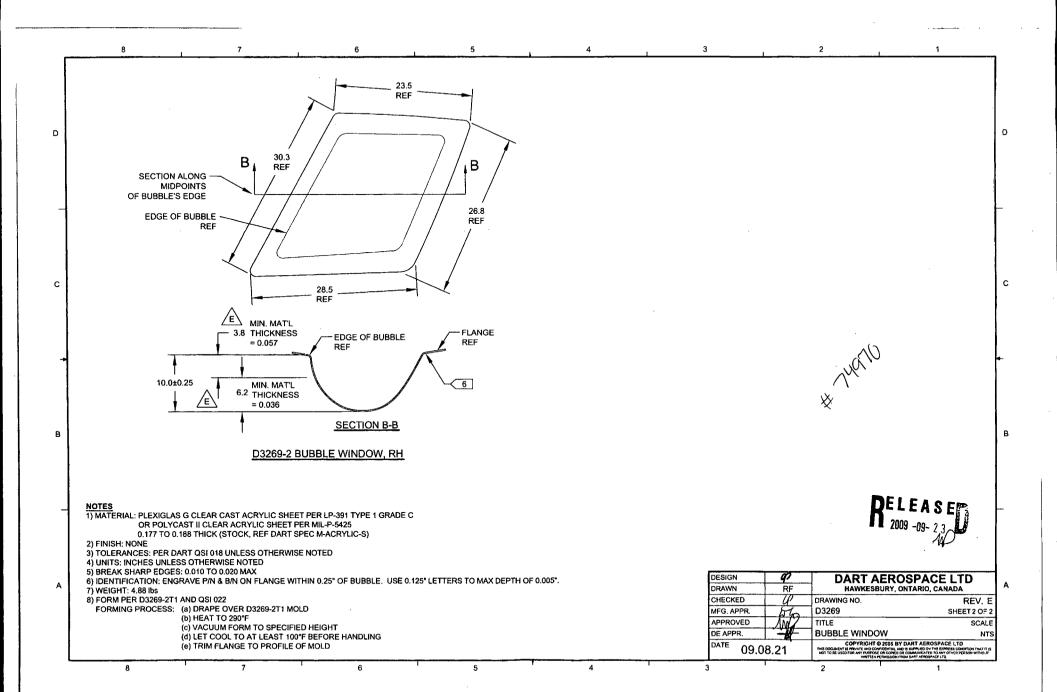
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W/O:			W	ORK ORDER CHAI	NGES				
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Зу	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	egory:	NCR:	Yes N	o DQA:	Date:	
	R	esolution:	Dispositio	on:	QA: N	/C Clos	sed:	Date: _	
NCR:		\	NORK ORD	ER NON-CONFOR	MANCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Description Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
										-	
Part No:		PAR #:	Fault Category:			NCR: Yes No DQA:			Date:		
	R	esolution:	Disposition:			A: N/C Closed:			Date:		
NCR: WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Sign 8	Verification			Approval	
	<u> </u>	Section A	Chief Eng	Chief E	ng	Date	Secti	ion C	Chief Eng	QC Inspector	
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